

Date: Monday, 6/5/2006 7:48:09 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLATE  
 Job Number : 27382  
 Estimate Number : 10643  
 P.O. Number : N/A Part Number : D31633  
 This Issue : 6/5/2006 S.O. No. : N/A Drawing Number : D3163 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 25023 Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 6/30/2006 Qty: 4 Um: Each  
 Checked & Approved By : 06.06.05 W  
 Comment : Est. B 05.40.25 Remove Powder Coat KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :\*

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: \_\_\_\_\_  
 Email or Ship DXF file to vendor  
 Laser Cut flat pattern per Dwg D3163  
 Possible Supplier: GFI  
 Material release note is required

M2024T35063 0.063" thick

Batch: M101022

(0.328 sqft) M100607

2.0 D31633F Water jet Plate



Prog. Rev. C  
 Dwg Rev. C



M100607 (4)

Comment: Qty: 1.0000 U(s)/Unit Total: 4.0000 U(s)

Plate

3.0 PACKAGING+ QC2 PACKAGING RESOURCE #1



M100607 (4)



Comment: PACKAGING RESOURCE #1

Receive & inspect for Transit Damage  
 Ensure Material Release Note is attached

4.0 QC6 QC8 DIMENSIONAL CHECK



060608 (4)



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Debur

SAD 060611

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 04/06/14

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:48:09 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 27382

Part Number: D31633

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:06:11

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06-06-12

4

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Small Lab. G.A-

PF 06-06-13

4

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/06/14

(4)

Job Completion



u 06-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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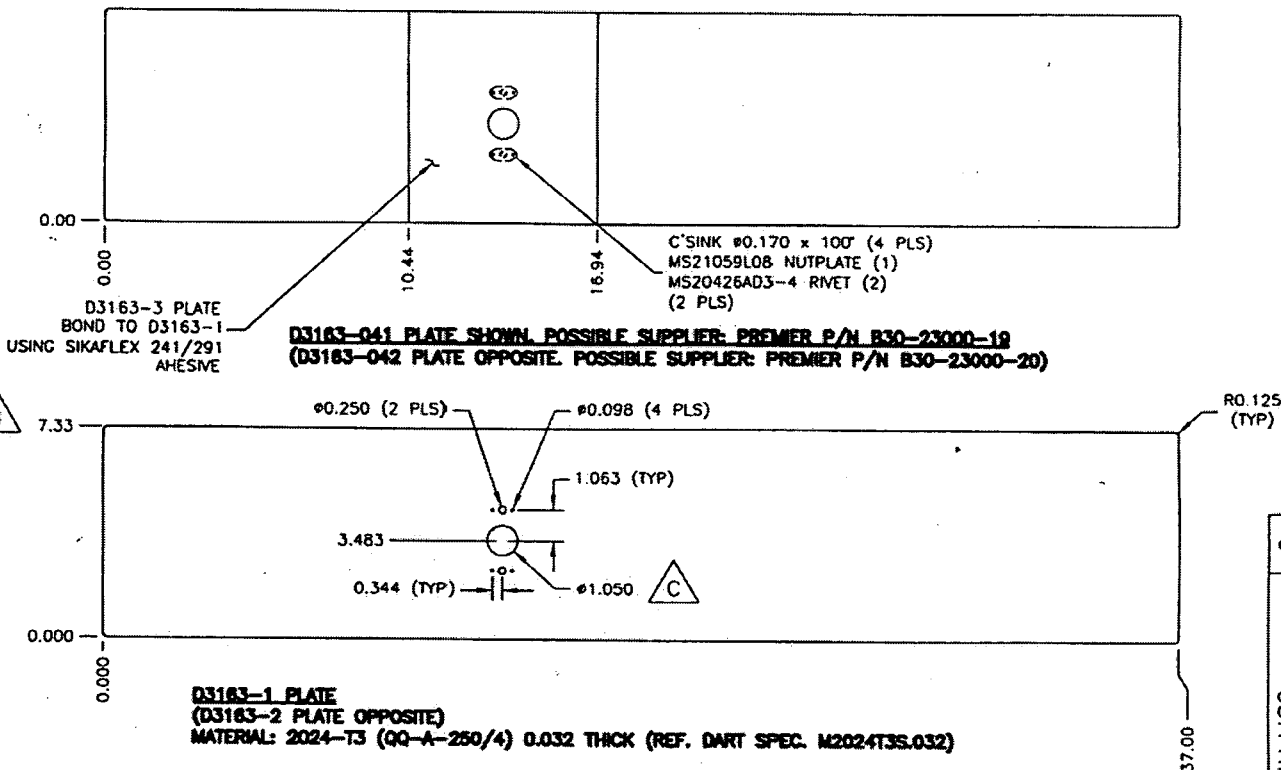
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

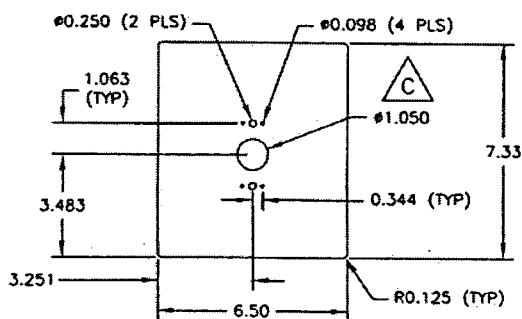
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.22	DRAWING NO.	D3163	REV. C
		TITLE	PLATE	SHEET 1 OF 1
A	02.04.26	NEW ISSUE		SCALE
B	04.10.06	7.33 WAS 7:20; REMOVE PERIMETER HOLES		1:6
C	05.11.22	Ø1.050 WAS Ø1.000		



**D3163-1 PLATE**  
(D3163-2 PLATE OPPOSITE)  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032)



**D3163-3 PLATE**  
MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)

**GENERAL NOTES:**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 27382

**RELEASED**

05.12.08

